

Work Order ID 133950

Tuesday, June 23, 2015 3:25:17 PM

133950

Page 1

Item ID: D2370-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Litter Frame Assembly

Start Date: 6/23/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/23/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: JUN 24 2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2370	REV D

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue p/o: 28933

Order: Model 12-2A undrilled with grey pad & black belts

Supplier: Ferno Aviation

Letter of compliance required

CY

JUN 24 2015

110

0.00

110

Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Insure that letter of compliance is attached to w/o

1X 5015-06-36

120

0.00

120

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

①

DAS
38
8-89

JUL 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

1- Assemble D2374 STUDS WITH HARDWARE as per Dwg D2370
2-Assemble d2379 belt as per dwg

1 FF JUL 06 2015

140

QC5- Inspect part completeness to step on W/O 0.00

140

QC

Memo

0.00

Quality Control

Check for loose rivet and ensure fit of D4812-041

① DAS 38 9-89 JUL 06 2015

150

Identify as per dwg & Stock Location: GA 0.00

150

Packaging

Memo

0.00

Packaging

LOCATION : GA

DAS 27 9-89

JUL 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

JUL 07 2015

JUL 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐											

Picklist Print

Tuesday, June 23, 2015 3:25:17 PM

Page 1

Work Order ID: 133950

133950

Parent Item: D2370-1

D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1P		Purchased	No				Each	0.0000		1			
D2370-1P									**	1x SP506-30			
Litter Frame Assembly													
D2374		Manufactured	No				Each	10.0000		4			
D2374									**	FF	JUL 06 2015		
Stud													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST006			10			4			
				131804			10						
D2378		Manufactured	No				Each	26.0000		4			
D2378									**	FF	JUL 06 2015		
Bolt													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST006			26			3			
				131082			25			1			
				131924			1						
D2484		Manufactured	No				Each	18.0000		4			
D2484									**	FF	JUL 06 2015		
Locknut													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				GA			18			4			
				130922			18						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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OTHER : _____					

Picklist Print

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D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

Each

4,785.000

4

NAS1149D0416.I

**

FF

JUL 06 2015

WASHER

Location

Loc Qty

Loc Code

ST270

4785

m131511

4785

7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

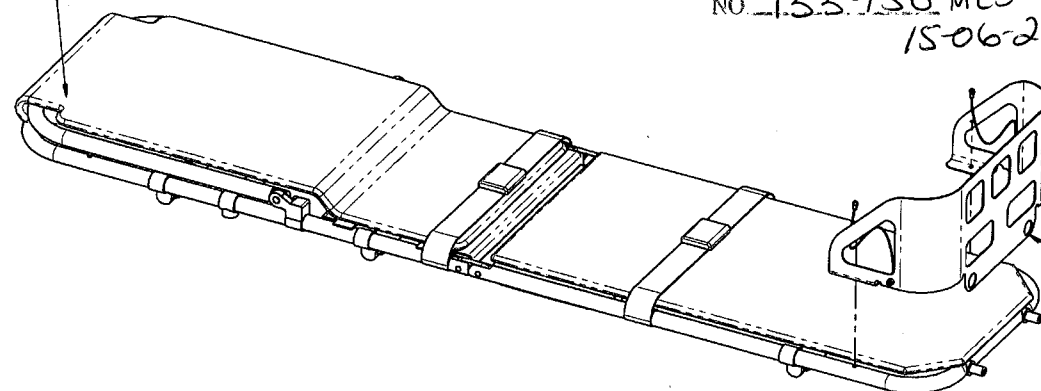
Work Order update only ☐

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133950 MLJ
15-06-24

D2370-1 LITTER FRAME ASSEMBLY



D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

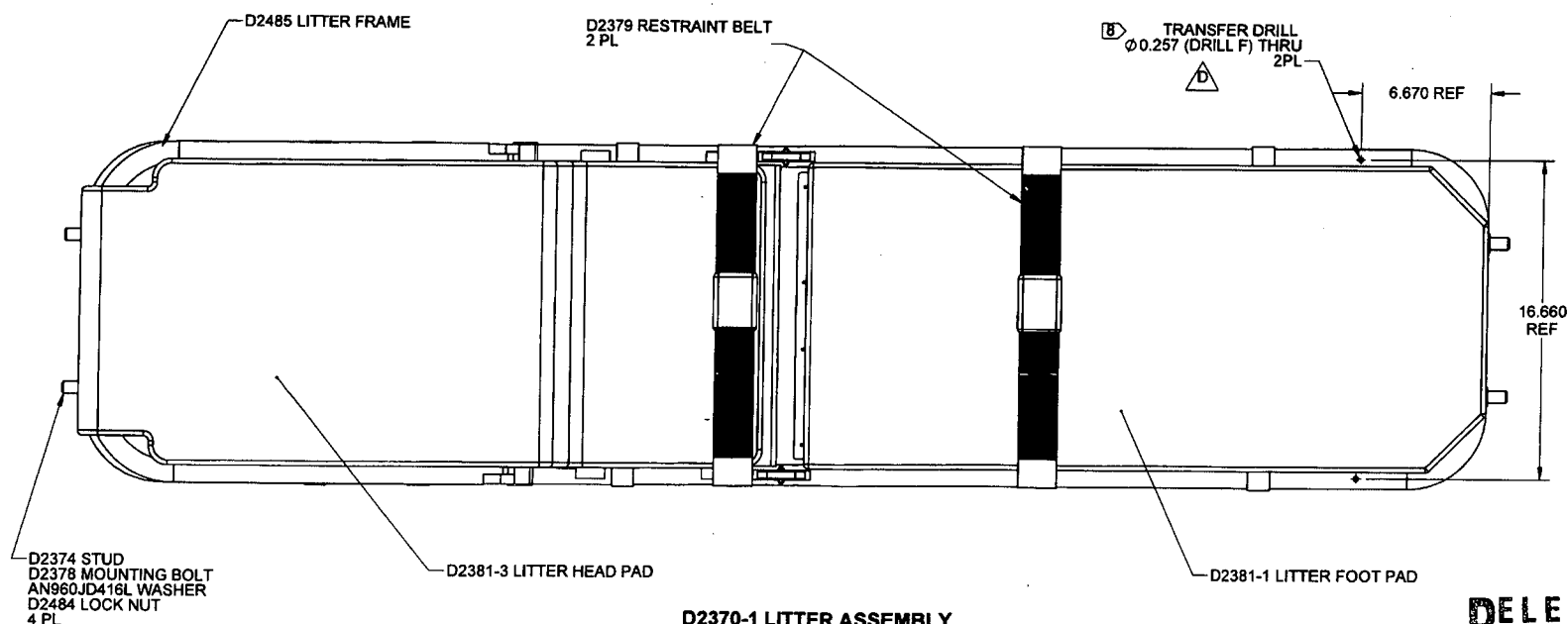
D2370-041 LITTER ASSEMBLY

RELEASED
2013-05-16
MD

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 25.73 Lbs

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>2/</i>	D2370	SHEET 1 OF 2
APPROVED	<i>2/</i>	TITLE	SCALE
DE APPR.	<i>2/</i>	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QSI 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	DB	
CHECKED	A.P.	DRAWING NO. D2370
MFG. APPR.		REV. D SHEET 2 OF 2
APPROVED		TITLE LITTER ASSEMBLY
DE APPR.		SCALE NTS
DATE	13.03.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EMPLOYED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
2013-05-16



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28933**

Purchase Order Date 6/24/2015 1:32:19 PM

PO Print Date 6/24/2015

Page Number 1 of 2

Order From :

VU-FER001

Ship To : DART AEROSPACE LTD

FERNO AVIATION INC.
735-B BRANCH DR.
ALPHARETTA, GA 30004
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Contact Name

Vendor Phone 770 521 1005

Ship To Contact

Ship To Phone

Ship Via: Fedex P1

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2370-1P AS PER DGW D2370 REV. D B133949	Litter Frame Assembly	7/6/2015 Yes 7/6/2015		1.00 Each	\$1,706.00	\$1,706.00
Line Total:							\$1,706.00
2	D2370-1P AS PER DGW D2370 REV. D B133950	Litter Frame Assembly	7/6/2015 Yes 7/6/2015		1.00 Each	\$1,706.00	\$1,706.00
Line Total:							\$1,706.00

PO Instructions: Fedex Acc#151793240

Note:

6/24/2015

FERNO Aviation, INC.

735-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

Packing Slip

DATE	PACKING SLIP NO.
6/25/2015	15723

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO28933

P.O. NUMBER	TERMS	REP	SHIP DATE	SHIP VIA	FOB	
PO28933	Net 30	CW	6/25/2015	FedEx Economy	Alpharetta,GA	
ITEM	DESCRIPTION				QTY ORD.	QTY DEL
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints S/N: 15N329707, 15N329708 (HS Code 8803.30.00.00)				2	2
Sp 15-06-30						

--



P 937.382.1451
F 937.382.1191

70 Weil Way
Wilmington, Ohio 45177

877.733.0911
www.ferno.com

Certificate of Conformance

Supplier: Ferno-Washington Inc.

Supplier Address: 70 Weil Way
Wilmington, Ohio 45177 USA
937-382-1451

Order No. 168025

Reference P.O. Ferno Aviation PO#: 9029
Oart PO# 28933

Model No. Model 12-2 Stretcher

Item Number: Ferno-Washington #
0163255 12-2 STRETCHER GRAY

Ferno Catalog Number: N/A

Serial Nos. 15N329703, 15N329704, 15N329705, 15N329706, 15N329707,
15N329708, 15N329709, 15N329710, 15N329711, 15N329712

I certify that the above referenced products are produced in accordance with applicable Ferno-Washington Inc. quality standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices.

Ferno-Washington Inc. is a registered manufacturer (Registration No. 1523574) with the United States Food and Drug Administration (FDA) as a manufacturer of medical devices, the Quality Management System is in compliance to the FDA's Code of Federal Regulations 21 CFR Part 820.

Ferno-Washington, Inc. also maintains a Quality Management System that fulfills the requirements of ISO 9001:2008 and ISO 13485:2003. Copies of Ferno-Washington, Inc.'s ISO 9001 and ISO 13485 certificates issued by Intertek are available upon request.

Frank Camasta
Director of Quality
f.camasta@ferno.com



P 937.382.1451
F 937.382.1191

70 Weil Way
Wilmington, Ohio 45177

877.733.0911
www.ferno.com

2015

Burn Certificate

Order No. 168025

Reference P.O. Ferno Aviation PO#: 90289
Dart PO# 28133

Model No. Model 12-2 Stretcher

Item Number: Ferno-Washington #
0163255 12-2 STRETCHER GRAY

Serial Nos. 15N329703, 15N329704, 15N329705, 15N329706, 15N329707,
15N329708, 15N329709, 15N329710, 15N329711, 15N329712

We certify that the material(s) listed above complies in all respects with the flammability requirements of the Department of Transportation Federal Aviation Administration FAR 25.853 appendix F Part I (a)(1)(ii).

FAR 25.853 "...The average burn length may not exceed six inches and the average flame time, after removal of the flame source, may not exceed 15 seconds. Drippings from the test specimen may not continue to flame for more than an average of three seconds after falling.

Frank Camasta
Director of Quality
f.camasta@ferno.com

Aircraft Belts Inc.
1176 Telecom Drive
Creedmoor NC 27522



Form: SC-108B
Phone: (800) 847-5651
Fax: (919) 956-4220

Print Date: 5/29/2015
Print Time: 11:48:29AM
Page: 1

FAA R.S. #: YB1R632K

PACKING SLIP / CERTIFICATION

Packing Slip: 22127

Cust. ID: F38

TERMS: Net 30

Ship To:

Ferno Aviation
735-B Branch Drive
Alpharetta GA 30004

Sold To:

Ferno Aviation
735-B Branch Drive
Alpharetta GA 30004

PO: 9113
Ship Date: 5/29/2015

Ship Via: UPS 1- Ground
SO: 97956

FOB: ORIGIN
Sales Person: Duncan, Virginia

***** Ship UPS Ground acct # E1129E *****

Line	Planned Qty	Shipped Qty	Backorder	Part Number	Revision
1	10.00 EA	10.00	0.00	STFL	D
Description: STFC3030-810 Stretcher Belt -					
2	50.00 EA	50.00	0.00	STFL	D
Description: STFC3030-810 Stretcher Belt -					

CERTIFICATION

This is to certify that the above components have been manufactured, rebuilt or repaired and inspected in accordance with current Federal Aviation Regulations: TSO-C22 and/or TSO-C114 and found airworthy for service unless otherwise noted. The conditions and tests required for TSO approval of this article are minimum performance standards. It is the responsibility of those desiring to install either on or within a specific type of class of aircraft to determine that the aircraft installation conditions are within the TSO standards. If not within the TSO standards, the article may be installed only if further evaluation by the applicant documents an acceptable installation and is approved by the administrator. Details of this manufacture, rebuild or repair are on file at this facility. Refer to packing slip for additional details.

BY: